

SPLIT-1

Dart Aerospace Ltd.

Date: Wednesday, 3/26/2008 9:54:04 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEBBING
 Job Number : 38177
 Estimate Number : 10755
 P.O. Number :
 This Issue : 3/26/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : PURCHASED PARTS
 Previous Run : 32586
 Written By :
 Checked & Approved By : JD 08.3.27
 Comment : Est: A 05.02.09 New Issue KJ/JLM

Part Number : D3320041
 Drawing Number : D3320 REV. A C
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 4/1/2008 Qty: 10 Um: Each

ORDER QTY 1
 ONLY FOR TRIAL.
 IF OKAY, WILL PURCHASE MORE

Additional Product



Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: ~~6099~~ 6117
 Fabricate D3320-041 as per Dwg D3320
 Possible Supplier: Aerotex or Tulmar
 Material release note is required

C208104108

①

Pro →

2.0 D3320041P Webbing



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)
 Webbing

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Receive & Inspect for Transit Damage
 Ensure Material Release Note is attached

P20410

①

P. 8/7/8 ④

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 00102/05 ④

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

AS 08107/08

FE-14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.07.06	3	DEVIATIONS LISTED ON ATTACHED AND DWG	PA 06.07.06 QSI 042	OKAY TRIAL FIT ON LID SUCCESSFUL	PA 06.07.06 QSI 042 SEE ATTACHED	06/07/06	PA 06.07.06 QSI 042 SEE ATTACHED	06/07/06

NOTE: Date & initial all entries

Date: Wednesday, 3/26/2008 9:54:04 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING

Job Number: 38177

Part Number: D3320041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

08/07/09

Job Completion



U 08/07/09

POSITIVE RECALL

EFFECTIVE

08/07/08

AUTH

U

RELEASED

U

DATE

08/07/09

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

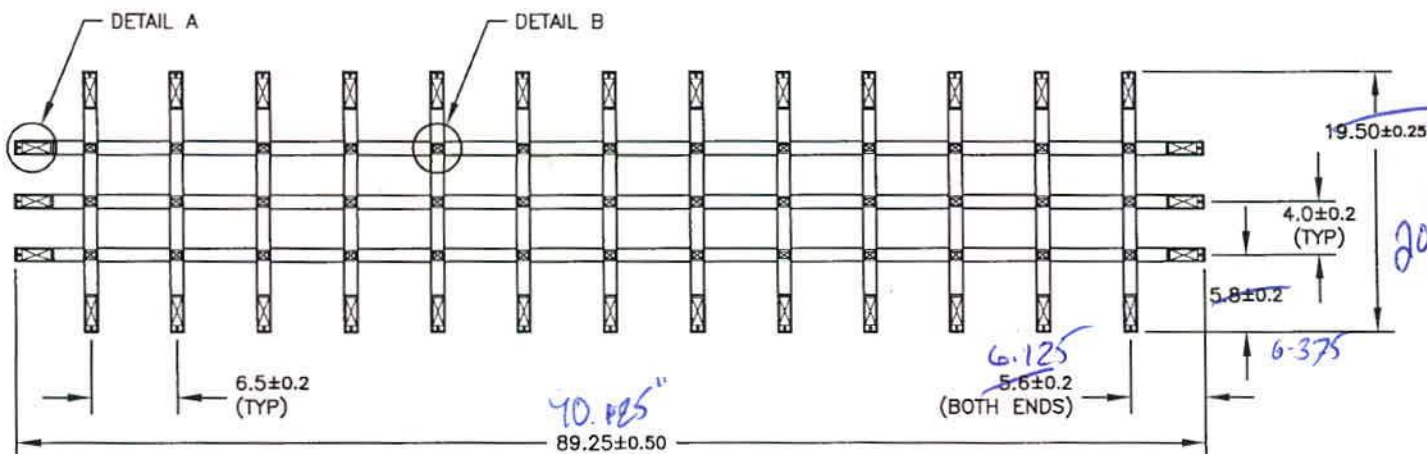
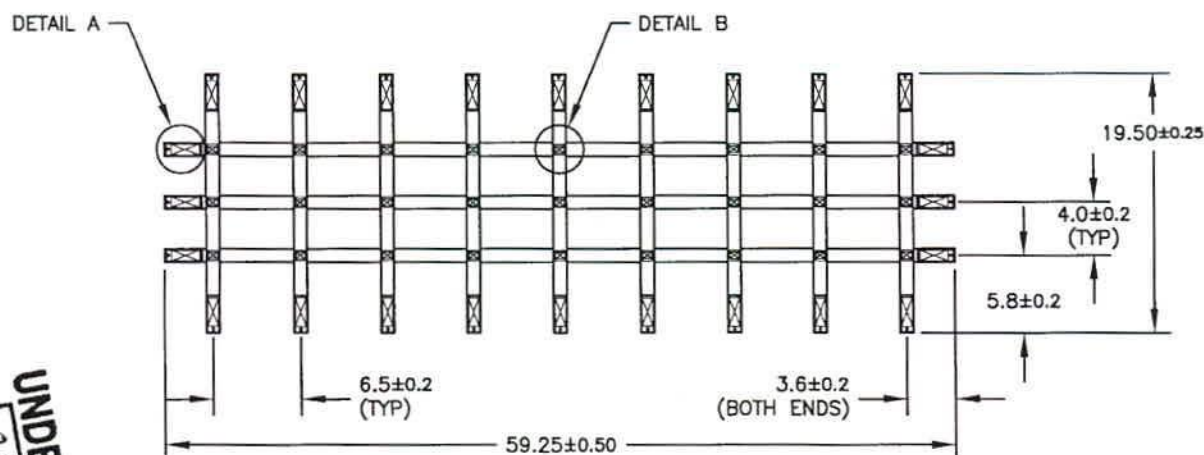
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD	
PH		J.B.		HAMKESBURY, ONTARIO, CANADA	
CHECKED	CE	APPROVED	PH	DRAWING NO.	REV. B
DATE		TITLE		SHEET 1 OF 2	
07.05.29		WEBBING		SCALE	
A		04.09.28		NEW ISSUE	
B		07.05.29		REVISED TOLERANCE AND REFORMAT	

**D3320-041 WEBBING****D3320-043 WEBBING****NOTES:**

- 1) WEBBING MATERIAL: NYLON, MIL-W-4088K, TYPE II, CLASS 1A, COLOR RED.
- 2) NYLON THREAD TO BE USED FOR ALL SEAMS CONFORMING TO V-T-295 TYPE II, CLASS A, SIZE F, COLOR RED.
- 3) STITCH PATTERNS TO CONFORM TO DETAILS A AND B.
- 4) ALL STITCHING TO BE MACHINE STITCHED IN ACCORDANCE WITH ASTM D6193 TYPE 301, 8-10 STITCHES PER INCH, MINIMUM 0.5" BACK STITCH.
- 5) HOT CUT WEBBING ENDS TO PREVENT FRAYING.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.

RELEASED

07.07.19

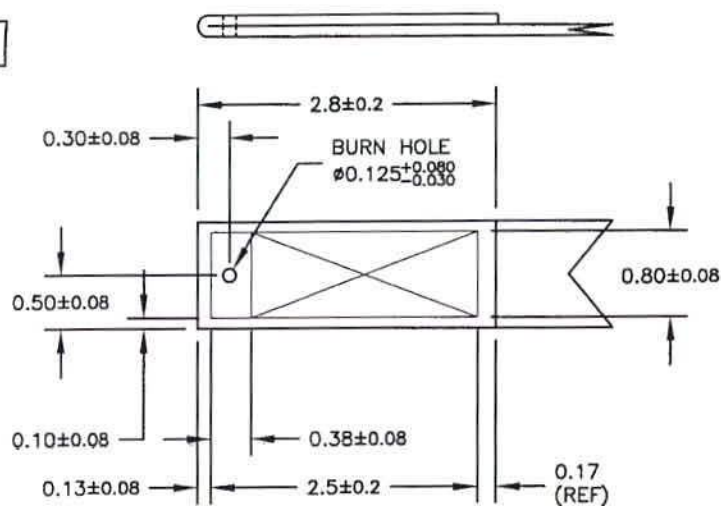
UNDER REVIEW

03.03.25

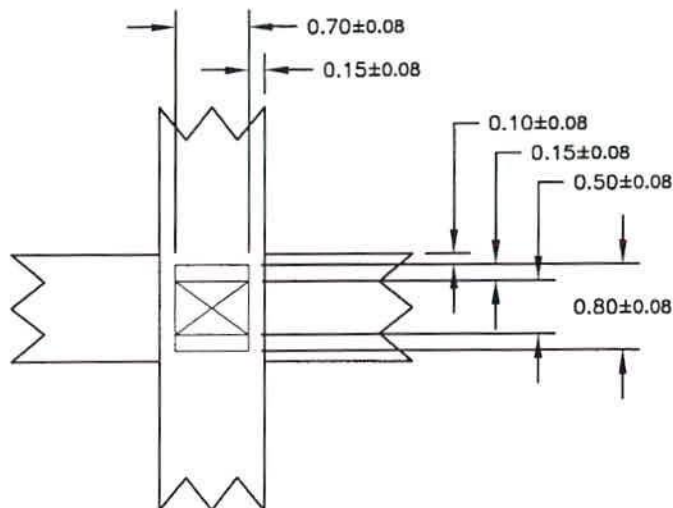
SHOP COPY
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WITHOUT NOTICE
WORK ORDER
NO. 38177

DART

DESIGN PH	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED AH	DRAWING NO. D3320	REV. B SHEET 2 OF 2
DATE 07.05.29	TITLE WEBBING		SCALE NTS

RELEASED07.07.19 **AH****DETAIL A**

TYPICAL WEBBING TERMINATION DETAIL

UNDER REVIEW
08.03.25 **PH****DETAIL B**

TYPICAL WEBBING INTERSECTION STITCH DETAIL

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#24, 2333 - 18 Ave NE
Calgary, AB T2E 8T6
Phone: (403) 295-8770
Fax: (403) 313 0793

Packing Slip

Date Packing Slip#

7/7/2008

5441

Ship To

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Invoice To

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Customer Phone

Customer Fax

1-613-632-3336

1-613-632-4443

Ship Via

Courier Acct No.

FedEx

15179324-0

Ship Date

P.O. No.

7/7/2008

6313

Item

Description

Part Number

Qty

SKI WEB NET

SKI BASKET WEB NET
GST On Sales

D3320-041

4

Thank you for doing business with Aerotex Interiors!

www.aerotexinteriors.com

GST/HST No.

139110308

Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: Thursday, May 15, 2008 5:53 PM
To: 'Peter Hum'
Subject: RE: D3320-041 deviations on part received from Aerotex

Peter,

The deviations described below are acceptable to me as long as the slack is similar to what we had with the old webbing. Please update the drawing as soon as possible.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Thursday, May 15, 2008 10:32 AM
To: 'David Shepherd'
Subject: D3320-041 deviations on part received from Aerotex

David,

I've attached pictures of the webbing installed on the basket lid.

Attached are the deviations on the dimensions for the D3320-041:

- a) Overall length increased by 1"
- b) Overall width increased by 1"
- c) End stitching detail is further from the end of the part (0.30" was 0.13"), subsequently the location of the burn hole move in to 0.50"
- d) Overall length of the stitch has decreased to 2.0"
- e) As shown in 1 of the attached pictures, there is some slack in the webbing about 1.5" maximum

c) and d) are caused by the manufacturing capabilities of Aerotex.

The dimensions I have circled will be the "new" nominal dimensions when the drawing gets revised. Additionally, the length of the rivet that fastens the webbing will need to be increased by 1 or 2 sizes (due to increased thickness).

Are these acceptable deviations?

Peter

No virus found in this incoming message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 269.23.16/1434 - Release Date: 5/15/2008 7:24 AM

No virus found in this outgoing message.

Checked by AVG.

Version: 7.5.524 / Virus Database: 269.23.16/1434 - Release Date: 5/15/2008 7:24 AM

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7

6

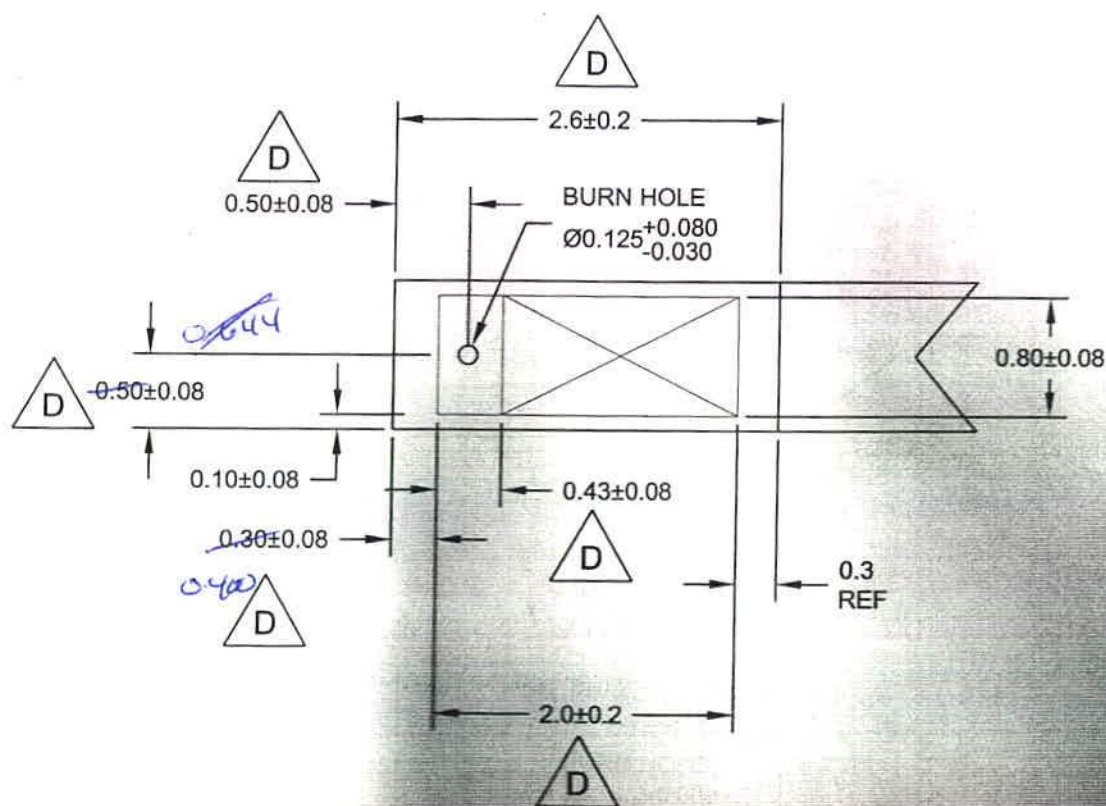
5

D

C

B

A



8

DETAIL A D8-1, C8-1**REFERENCE ONLY**



- Unit 24, 2333 - 18 Ave NE, Calgary AB T2E 8T6 - Phone: (403) 295 - 8770 - Fax: (403) 313 - 0793 -

CERTIFICATION OF CONFORMANCE

Customer Purchase Order:
Our Work Order:

6313

5441

order/02

THIS IS TO CERTIFY THAT THE FOLLOWING MATERIALS HAVE BEEN USED IN THE WORK ORDER STATED ABOVE:

WEBBING - MIL-W-4088 RED T 17

HAS BEEN FABRICATED TO ESTABLISHED SPECIFICATION TO CONFIRM WITH
DWG D3320 REV C.

SOLD TO:
DART AEROSPACE LTD., 1270 ABERDEEN STREET, HAWKESBURY, ON K6A 1K7

AUTHORIZED REPRESENTATIVE

[Handwritten signature]